D 35 35 - 37 Work Order ID 111879 *111879* Page 1 B111879 January-24-14 8:25:43 AM Item ID: D3535-37 Accept *N900040100* Setup Start **Revision ID: Item Name:** Stainless Steel Wearplate Aft Start Qty: 8.00 *8* **Start Date:** 1/24/14 **Cust Item ID:** Required Date: 2/07/14 **Reg'd Qty:** 8.00 *8* **Customer:** Reference: Run Start Date: 14-01-24 Tooling: Process Plan: MLゴ **Approvals:** Date: Stop QC: Date: _____ SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Number **Qty** Stamp Draw Nbr **Revision Nbr** D3535 Rev B 100 0.00 FLOW WATER JET *100* 8 0_ Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3535 Dwg Rev: Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* OC 0.00 Memo **Quality Control** DAS 120 QC8- Inspect parts - second check 0.00 27 QC Memo Quality Control

	DQA:			Date:											7	
Work Order: Part No. Part No. Rework Skid-tube Crosstube Small Fab Prod. Eng. Coor. Quality Quality Prod. Eng. Coor. Prod. Eng.							WORK ORDER NON	-CC	ONFO	RMANCE / U			, r			AEROSPACE
Rework Scrap Skid-tube Crosstube Prod. Eng. Coor. Quality Quality Other Suspected Unapproved Large Fab Composite Sign & Supplier Other Suspected Unapproved Suspected Unapproved Composite Sign & Suspected Unapproved Other Suspected Unapproved Composite Sign & Suspected Unapproved Other Other	QA Closed:			Date:							· · · · · · · · · · · · · · · · · · ·	Wo	rk Order up	date only		
Rework Scrap Use-as-is Suspected Unapproved Skid-tube Crosstube Prod. Eng. Coor. Quality Quality Other Suspected Unapproved Cause Date Step Qty Or non-conformance Chief Eng Description Descrip	Work Order:	:					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
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Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data	NCR No	· <u> </u>				_	Suspected Unapproved			Large Fab	Composite			Supplier		
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111879

Page 2 January-24-14 8:25:43 AM Item ID: D3535-37 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Stainless Steel Wearplate Aft Start Date: **Start Otv: 8.00 ***2* 1/24/14 **Cust Item ID:** Required Date: 2/07/14 Rea'd Otv: 8.00 Customer: Reference: Run Start Process Plan: Date: **Approvals:** Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Reject Tool # Plan Accept Insp. Work Center ID Description Run Hours Code Otv Number Stamp **Qty** 130 0.00 NC BRAKE *120* Brake NC 0.00 Memo DAS Brake NC 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326, 2-30 Identify as D3535-37 9-89 DAS 140 QC5- Inspect part completeness to step on W/O 0.00 *140* OC 0.00 Memo Quality Control 150 Grey Sandtex(Ref:4.3.5.6) per Q\$1005 4.3 0.00 8 6 14-2-18. 25 *150*

Powdercoat

Powder Coating

Memo

OVEN TEMPERATURE:

DQA:			Date:											•	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI				_		AEROSPACE
QA Closed:			Date:							,	Wo	rk Order up	date only		
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Part N	lo.					Scrap		Machining Small Fal				Pro	d. Eng. Coor.		Quality
						Use-as-is		Thermoforming Finishing				Rec/Store/Packaging			Other
NCR N	lo.					Suspected Unapproved	Large Fab Composite						Supplier		
Root					Desci	ription of work order update	Initial Action			ion	Sign &				
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	Wave/Twist in Tube			oe		Fit/Function		Out of	Sequence						

111879

Page 3

January-24-14 8:25:43 AM Item ID: D3535-37 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Stainless Steel Wearplate Aft **Start Date: Start Qty:** 8.00 *8* 1/24/14 **Cust Item ID:** Required Date: 2/07/14 Reg'd Qty: 8.00 *****2* **Customer:** Reference: Start Run Tooling: **Approvals:** Process Plan: Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Number **Run Hours** Code Qty **Qty** Stamp 160 QC3- Inspect Part Finish 0.00 *160* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: [P.067 0.00 170 *170* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 MLJ 1402-19_ MLJ 1402-19 *120* OC 0.00 Memo Quality Control

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QA Closed.			Date.									•			
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	•					Rework			Skid-tube Crosstub	e]	Water Jet	Engineering		
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Cause		Date	Step	Qty		or non-comormance	Cii	iei ciig	Description		Date	vernication	QC IIIspector		
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	<u> </u>	Crushing			<u> </u>	Countersink	<u></u>	1 `	gned/off center	<u> </u>	Positioned V		٦		
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İ	\vdash	Turning S	•		<u> </u>	Finish	\vdash	-{	Calibration						
1	Wave/Twist in Tube					Fit/Function	L	Out of	Sequence						

Picklist Print

January-24-14 8:25:48 AM

Work Order ID: 111879

111879

Parent Item:

D3535-37

D3535-37

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 1/24/14

Required Date: 2/07/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		100	sf	203.8500	0.7955	7			
M304S20	GA							**			Ae 14	1.02.

304/316 .040 Sheet

Location Loc Qty Loc Code MAT020 203.85 m126852 3.55 127454 -> (7) m127454 200.3

DQA:			Date:	· ··· · · · · · · · · · · · · · · · ·									DART
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorr	eci	Temperature/Cure
		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/N	1issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/U	Inclear	Part Move	.	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned	Wrong	<u> </u>
	Heat Treat				Cut Too Short		Mislab	eled		Power Loss	/Surge	Other	
	\vdash			Drawing		Misrea	d	_					
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	111879
Description: Wearshoe	Part Number:	D3535-37
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	UPI.	1		V	JKm-05
0.300	+/-0.010	.302	_		V	
0.300	+/-0.010	1302	-		V	
1.885	+/-0.010	1.885			V	
2.000	+/-0.010	2.000	_		٧	
4.750	+/-0.010	4.750	_		7	JKM-06
9.500	+/-0.010	9.500	-		Τ.	
14.250	+/-0.010	14.250	(7	
17.750	+/-0.010	17.750	(7	
22.500	+/-0.010	22.500	(T	
27.250	+/-0.010	27. 250	-		T	
30.750	+/-0.010	36.750	-		Т	
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Measured by: 4e

Date: 14.02.13

Audited by: 3-89

Date: 14.02.13

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	09.10.16	New Issue	KJ 👯	77
				

DQA:			Date:										TQ AC
						WORK ORDER NON	-CC	ONFO	RMANCE / UPE				AEROSPACE
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	Crushing					Countersink		Misali	gned/off center		Positioned V	Vrong	_
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	Heat Treat Inspection Strip in Tube			-	Drawing		Misrea			L	Jrower Loss/	ouige [Ouiei	
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DQA:			Date:										DART		
						WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:							,	Vork Order u	odate only			
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Part N	lo.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	-					Use-as-is	1	l	noforming	Finishing		re/Packaging	Other		
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		Inspection	•	Tube	\vdash	Drawing	<u> </u>	Misrea							
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure	
		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld	
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled	
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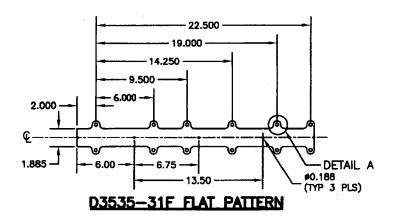
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D3535-31 BEND DETAIL

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	D3535-33F FLAT PATTERN

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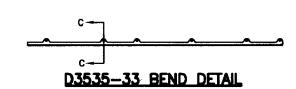
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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT Q.
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



DQA:		····	Date:			WORK ORDER NON CONFORMANCE / LIDDATE									
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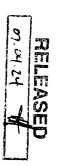
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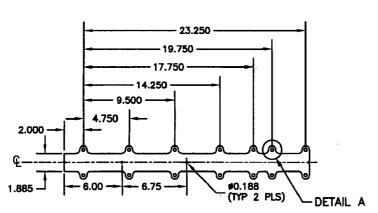
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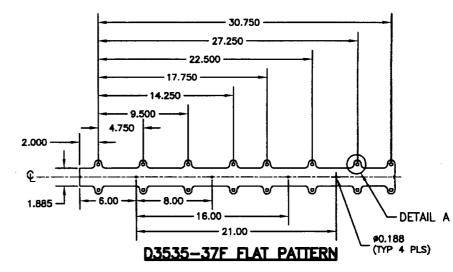
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D3535-35F FLAT PATTERN





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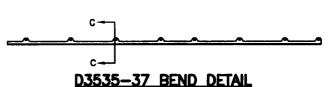
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PURPOSE

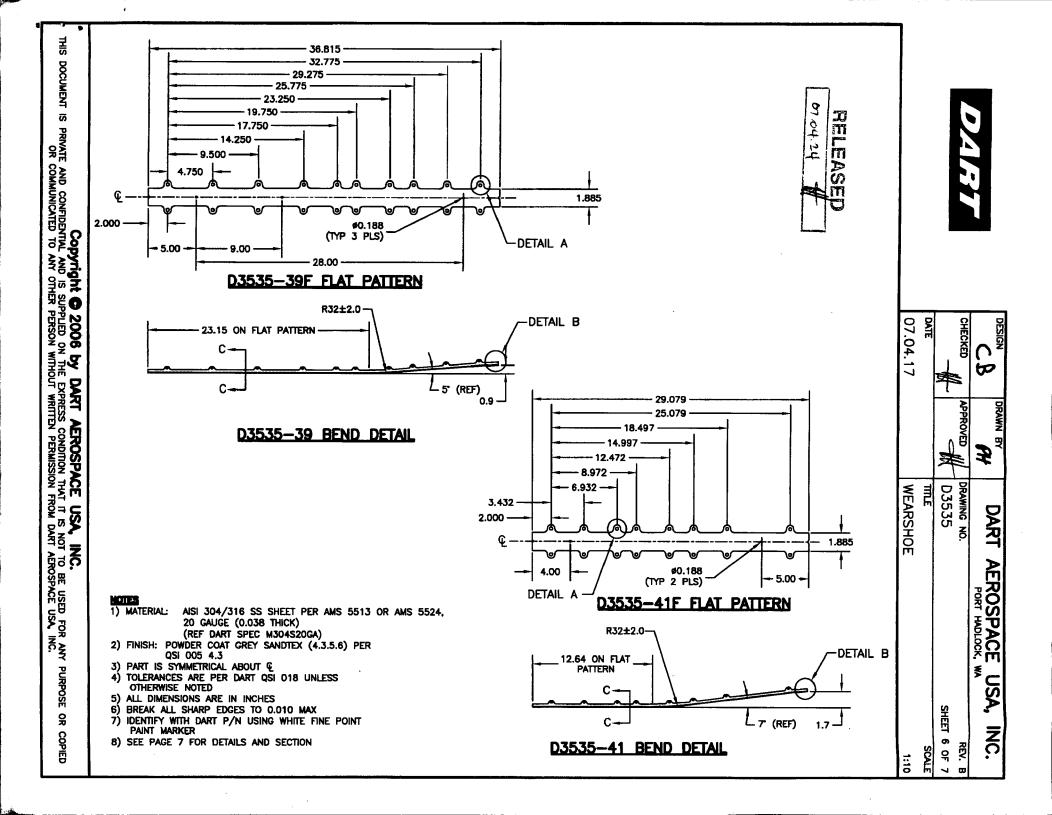
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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
- 20 GAUGE (0.038 THICK)
 (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



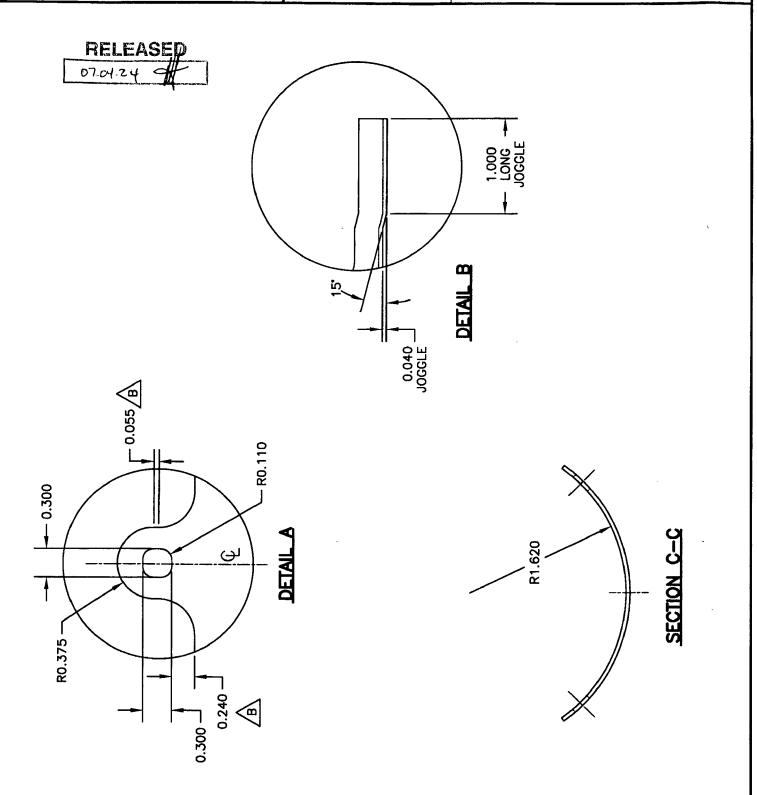
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
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		D3535	SHEET 7 OF 7
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